

Date: Wednesday, 10/10/2007 11:03:49 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35085
Estimate Number : 11235
P.O. Number :
This Issue : 10/10/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : THERMOFORMING
Previous Run : 33900

Drawing Name : FLOOR PROTECTOR AFT RH

Part Number : D32814
Drawing Number : D3281 REV B
Project Number : N/A
Drawing Revision :
Material :
Due Date : 11/2/2007 Qty: 20 Um: Each

Written By :
Checked & Approved By :
Comment : Est Rev A 04.07.01 New issue KJ/JLM
Est Rev B 07.08.07 Thermoform in house DL



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 F6002 701 lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total : 87.2000 sf(s)
lexan black .125"

Material Batch # M 106957

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 010

Dwg. Rev. B

Folio Rev.

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

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Drawing Name: FLOOR PROTECTOR AFT RH

Job Number: 35085

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Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 08.02.04 (X10)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

DL 08.02.05 (X10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 08.02.05 (X10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

266 8/2/6 SD (112X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DL 08.02.06 (X10)

Job Completion



DL 08.02.06

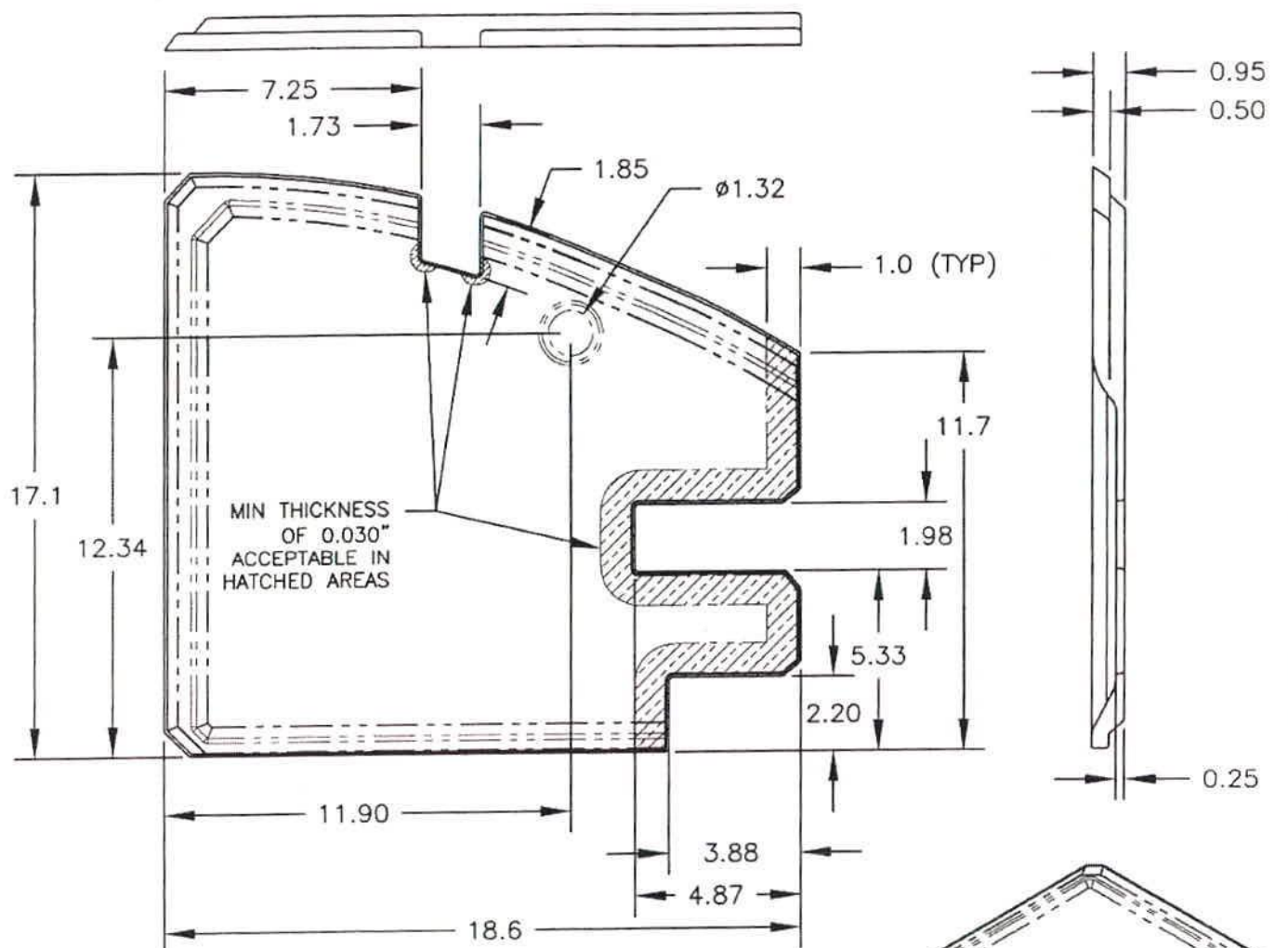
POSITIVE RECALL

EFFECTIVE 07/10/12 AUTH LL

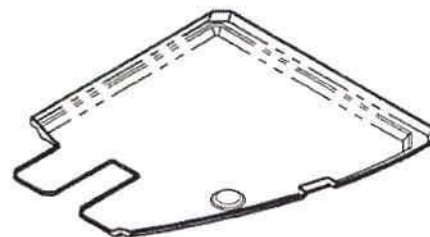
RELEASED LL DATE 08/01/04

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	HH	APPROVED	HH	DRAWING NO.	SHEET 1 OF 3
				D3281	
DATE	05.11.25			TITLE	SCALE
				FLOOR PROTECTOR	1:5
A	04.05.03	NEW ISSUE			
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED			

**RELEASED**
05.12.01**UNDER REVIEW**

07.10.05 LE

OK TO MANUFACTURE
AND SHIP**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

SHOP COPY
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WORK ORDER

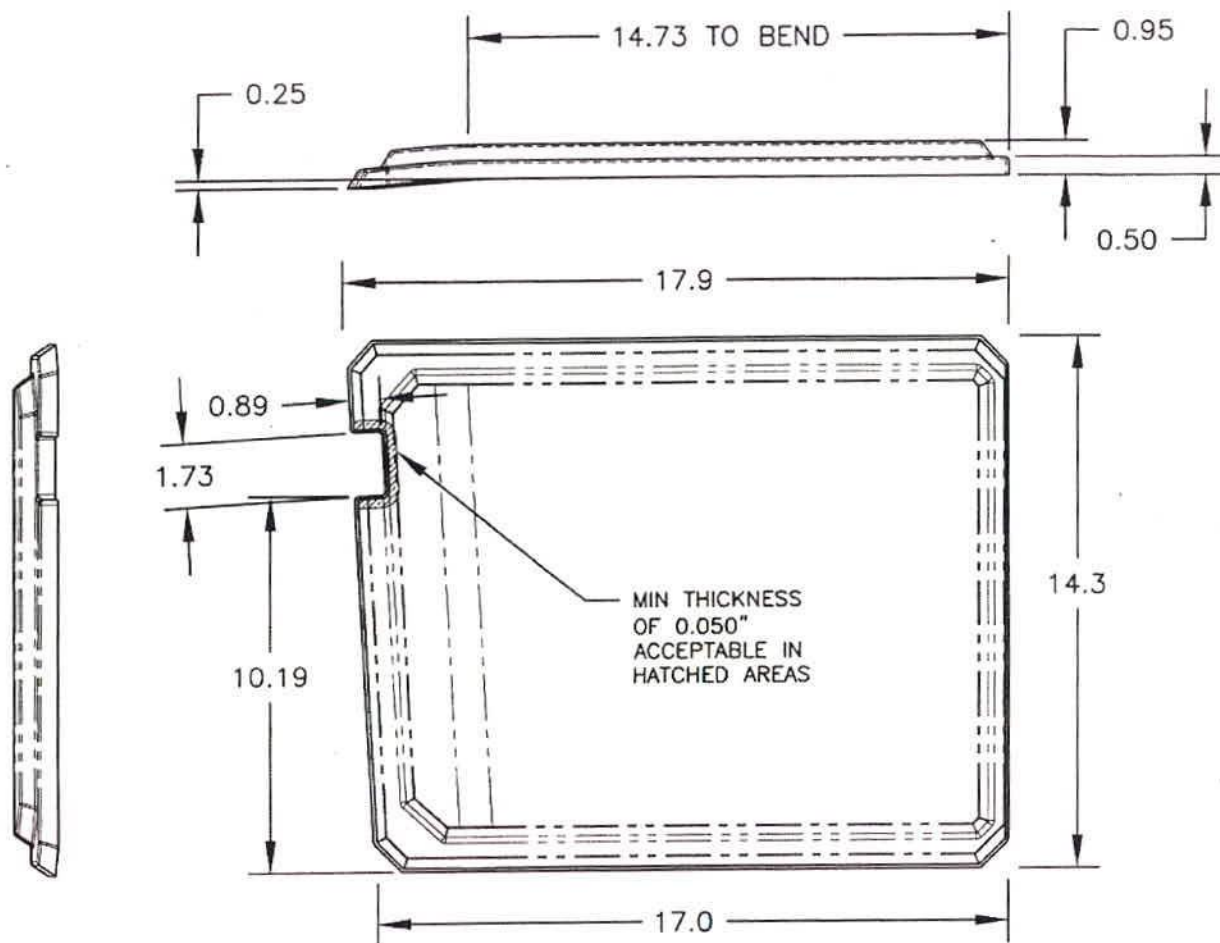
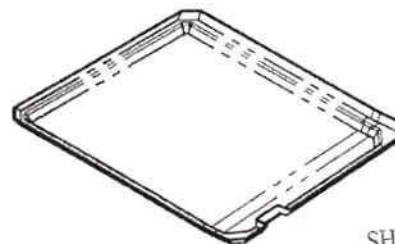
NO

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.12.01 *[Signature]***UNDER REVIEW**07.10.05 LE
OK TO MANUFACTURE
AND SHIP**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DART AEROSPACE LTD		Work Order:	35085-2
Description: R-44 FLOOR PROTECTOR AFT RH		Part Number:	D3281-4.
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u>	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: TBB

Date: 08/01/30

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.9	.1	17.8	✓			
14.3	.1	14.25	✓			
10.14	.1	10.125	✓			
.95	.030	.964	✓			
.25	.030	.25	✓			

Measured by: [Signature]

Date: 08.03.04

Audited by: [Signature]

Date: 08/02/04

Prototype Approval: [Signature]

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

[Signature]